

Date: Tuesday, 4/4/2006 1:27:32 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	26498	Part Number :	D2573
Estimate Number :	10533	Drawing Number :	D2573 REV E
P.O. Number :	N/A	Project Number :	N/A
This Issue :	4/4/2006	Drawing Revision :	E
Prsht Rev. :	NC	Material :	N/A
First Issue :	N/A	Due Date :	4/28/2006
Previous Run :	26362	Qty:	8
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	J. L. 06.04.04		
Comment :	Est: 1 AS Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B 24813

En/5.6

06/05/06

8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 26498 Double check by: J.L.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

En/5.6 06/05/06

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

En/5.6 06/05/06

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/5.6 06/05/06

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26498

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mt 06/05/09

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:05:09

8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-11

8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/05/11

8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57480*

06/05/11

8

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/12

8

Job Completion



06-05-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26498
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.746	1.746	1.746		
C	3.495	3.505		3.500	3.499	3.501	3.499		
D	1.745	1.755		1.745	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.493	0.494	0.498	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.497	0.499	0.497	0.497		
J	1.174	1.184		1.175	1.176	1.176	1.176		
K	0.558	0.578		0.563	0.564	0.564	0.568		
L	1.174	1.184		1.175	1.176	1.176	1.176		
M	1.365	1.375		1.365	1.366	1.367	1.367		
N	2.495	2.505		2.495	2.496	2.498	2.499		
O	4.119	4.129		4.122	4.121	4.120	4.121		
P	0.115	0.135		0.120	0.120	0.119	0.120		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.257	0.249	0.248	0.247		
S	0.115	0.135		0.120	0.121	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.231	3.232		
V	0.230	0.250		0.236	0.239	0.238	0.239		
W	0.115	0.135		0.121	0.123	0.120	0.121		
X	0.308	0.313		0.309	0.312	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.365	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.631	0.634	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.244	0.243		
AE	1.500	1.520		1.510	1.512	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.252	0.251	0.252		
AI	2.000	2.020		2.000	2.001	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / S.G
Date:	06/05/06

Audited by:	ml
Date:	06/10/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	26498
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Inspection Dwg: D2573 Rev. E		Page 1 of 1

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B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.498	3.497	3.499	3.498		
D	1.745	1.755		1.746	1.747	1.746	1.747		
E	7.990	8.010		8.003	8.004	8.003	8.002		
F	0.490	0.510		0.504	0.505	0.504	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.497	0.497	0.497	0.497		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.569	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.367	1.369		
N	2.495	2.505		2.499	2.499	2.501	2.499		
O	4.119	4.129		4.121	4.121	4.120	4.121		
P	0.115	0.135		0.120	0.122	0.124	0.125		
Q	0.115	0.135		0.133	0.131	0.130	0.131		
R	0.240	0.260		0.248	0.247	0.248	0.247		
S	0.115	0.135		0.118	0.119	0.120	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.231	3.231		
V	0.230	0.250		0.233	0.234	0.235	0.234		
W	0.115	0.135		0.122	0.122	0.122	0.124		
X	0.308	0.313		0.310	0.311	0.312	0.312		
Y	0.760	0.765		0.761	0.761	0.760	0.761		
Z	0.352	0.372		0.364	0.362	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.501		
AB	0.615	0.635		0.630	0.631	0.632	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.244	0.241	0.244		
AE	1.500	1.520		1.514	1.514	1.513	1.514		
AF	0.115	0.135		0.130	0.129	0.128	0.127		
AG	0.240	0.280		0.265	0.265	0.264	0.265		
AH	0.240	0.260		0.244	0.244	0.244	0.246		
AI	2.000	2.020		2.003	2.002	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	S.G.
Date:	06/05/07






Audited by:	ML
Date:	06/10/09

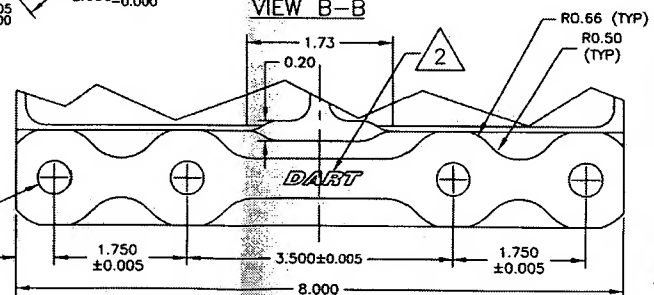
Rev	Date	Change	Revised by	Approved
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	




05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE LTD. HAMBURGERS, ONTARIO, CANADA
DS	PH	
CHECKED 	APPROVED 	DRAWING NO. D2573
DATE 05.07.13		TITLE OUTER AFT SADDLE SCALE 2:3

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